

# Work Order ID 85891

June-18-12 12:34:03 PM

ASAP

\*85891\*

Page 1

Item ID: D4021-5

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Blanking Plate

Start Date: 18/06/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/18 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4021	B

100

0.00

\*100\*

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per dwg D4021

304 .063"

Prog Rev: B

Dwg Rev: B

Deburr as required

26 0 Jm 12-6-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

20 0 Jm 12-6-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85891

**\*85891\***

Page 2

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Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

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Start Date: 18/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

**\*120\***

QC

Memo

0.00

5/26/20

cont  
x70

Quality Control

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

**\*130\***

Powdercoat

Memo

0.00

Start Time: 8-20

Temp: 400 F

20X

mf  
12/06/20

Powder Coating

MI 20222

Finish Time: 8-50

135

QC3- Inspect Part Finish

0.00

**\*135\***

QC

Memo

0.00

20X 4 11/10/20

Quality Control

W/O:		WORK ORDER CHANGES					
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Page 3

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Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Blanking Plate

Start Date: 18/06/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Identify as per dwg & Stock Location: 084

0.00

**\*140\***

Packaging

Memo

0.00

Packaging

20

12/06/20 JB

150

QC21- Final Inspection - Work Order Release

0.00

**\*150\***

QC

Memo

0.00

Quality Control

12/6/20 JB

MW 12/06/20

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

# Picklist Print

June-18-12 12:34:06 PM

Page 1

Work Order ID: 85891

\*85891\*

Parent Item: D4021-5

\*D4021-5\*

Parent Item Name: Blanking Plate

Start Date: 18/06/2012

Required Date: 25/06/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP RevA: new issue DD 09.11.25 verified by:EC IPP Rev:B as  
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as per dwg revB  
DD 10.04.20 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	44.8846	0.0622	1.309474			

\*M304S16GA\*

\*\*

Jm 12-6-19

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

44.884633

121889

44.884633

121889

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





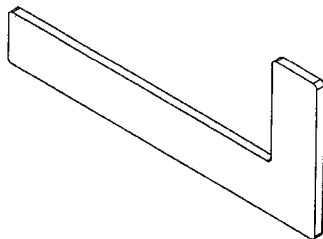
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

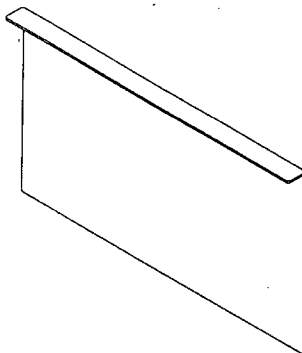
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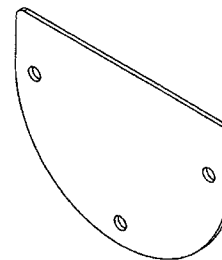
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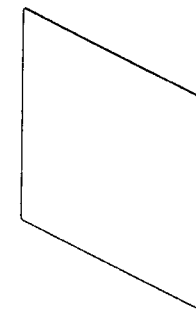
**D4021-1 HANDLE PLATE**



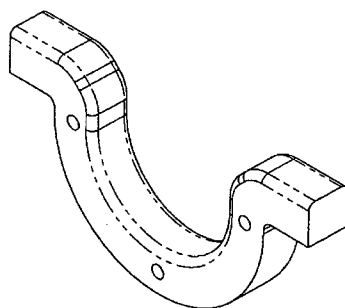
**D4021-3 DATA PLATE**



**D4021-5 BLANKING PLATE**



**D4021-11 INSTRUCTIONS PLATE**



**D4021-7 HOOP**



**D4021-9 BUSHING**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 05891 MLJ

12/06/18

**RELEASED**  
2010-04-14  
MP

B	POWDER COAT SPEC ADDED TO NOTE 2 (A&2)	JPH	10.04.06
A	NEW ISSUE	JPH	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D4021</b> REV. B SHEET 1 OF 3 TITLE <b>MISC PARTS - 350 BASKET</b> NTS COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	10.04.06		

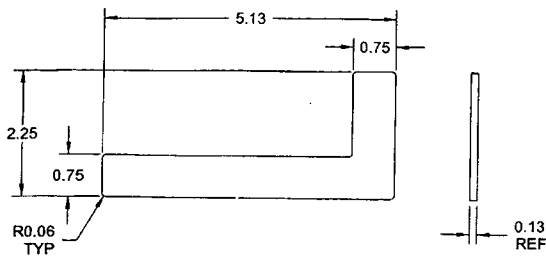
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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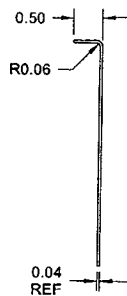
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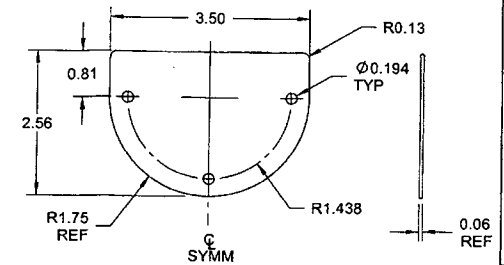
**NOTE:** Date & initial all entries



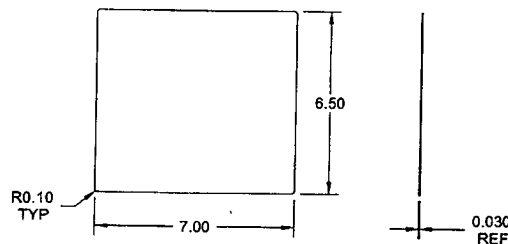
**D4021-1 HANDLE PLATE**



**D4021-3 DATA PLATE**  
MAKE FROM D4021-3F



**D4021-5 BLANKING PLATE**

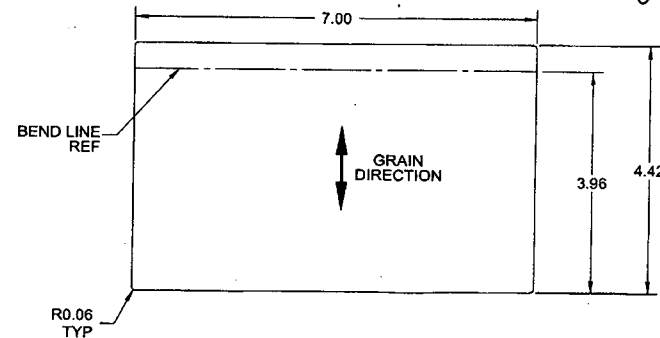


**D4021-11 INSTRUCTIONS PLATE**

**NOTES:**




- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE  
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs  
-3: 0.35 lbs  
-5: 0.14 lbs  
-11: 0.39 lbs



**D4021-3F DATA PLATE**  
FLAT PATTERN

**RELEASED**  
R 2010-04-11  
NM

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MISC PARTS - 350 BASKET	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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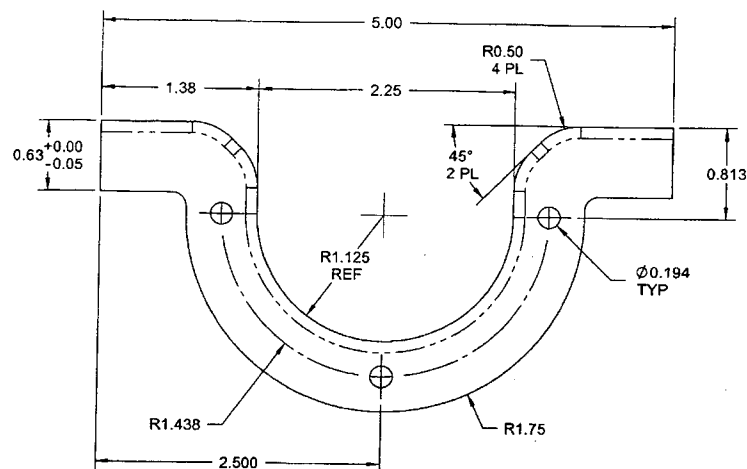
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

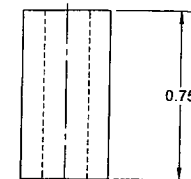
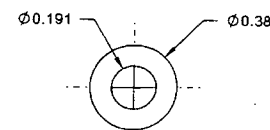
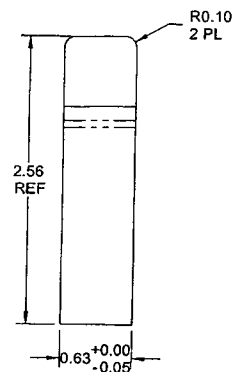
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**NOTE:** Date & initial all entries



**D4021-7 HOOP**



**D4021-9 BUSHING**

25491

**NOTES:**

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276  
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276  
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs  
-9: 0.02 lbs

**RELEASED**  
2010-04-14  
NR

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4021	SHEET 3 OF 3
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